

SPLIT L

Dart Aerospace Ltd.

Date: Tuesday, 11/14/2006 10:08:31 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 29411 -2	
Estimate Number : 12576	
P.O. Number : N/A	Part Number : D3562041
This Issue : 11/14/2006 S.O. No. : N/A	Drawing Number : D3562 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 29411	Material : N/A
Written By : [Signature]	Due Date : 11/24/2006 Qty: 5 Um: Each
Checked & Approved By : [Signature]	
Comment : Est Rev:A New Issue 06-11-09 JLM	

Additional Product

OIC. Proceed for HAS only. [Signature]

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	328215

Check Material for any Dents or Defects

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 32.15" long as per Dwg D3562

2-Deburr and bevel ends for welding

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	32934C

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Job Number: 29411

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D35601

ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3560-1

Arm

B29447

J.E. 06-12-27 5

6.0

D35603

ARM



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM

Batch:

B29449

J.E. 06-12-27 5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

Use DT8893 To Weld Arms

A/R Aluminum Rod M100237 & M19612

J.E. 06-12-28 5

2-Grind end cap welds flush as per Dwg D3562

J.E. 06-12-28 5

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/03 (5)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/03 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FCB 07/01/04 (5)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and bevel aft end for welding.

2-Weld as per Dwg D3562

a/r AL ROD

Batch:

M100237 M19612

J.E. 07-01-08 5
J.E. 07-01-08 5

Process Sheet

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Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/10 (5)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/10 (5)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JL

07/01/11 x5

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

JL

07/01/11 x5

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: 102095

SP/JL

07/01/11 (5)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf.

07-01-29

(5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

G.D.

mf. 07-01-29

(5)

Job Completion



07-01-30

